

Ship July 31

Work Order ID 134848

134848

Page 1

July 22, 2015 10:27:50 AM

Item ID: D4842-041

REV. B

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Lower Cutter Assembly

Start Date: 7/22/2015 Start Qty: 1.00

1

Cust Item ID:

Required Date: 7/31/2015 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan: 

Date: 15.7.22

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D4842

REV B

110

Pick Kit

0.00

110

Packaging

Memo

0.00

Packaging

IX

15/07/22
DAS 36 9-89

120

0.00

120

Small Fab

Memo

0.00

Small Fab

Assemble as per dwg and apply loctite 598 on all faying surfaces.

A/R LOCTITE 598: M130311

IX

15/07/22
DAS 36 9-89

130

QC5- Inspect part completeness to step on W/O

0.00

130

QC

Memo

0.00

Quality Control

①

JUL 27 2015
DAS 36 9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

Work Order ID 134848

134848

Page 2

July 22, 2015 10:27:50 AM

Item ID: D4842-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Lower Cutter Assembly
 Start Date: 7/22/2015 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 7/31/2015 Req'd Qty: 1.00 ***1*** Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	Identify as per dwg & Stock Location: _____	0.00				1	DAS 27 9-89		
140									
Packaging	Memo	0.00							
Packaging									
150	QC21- Final Inspection - Work Order Release	0.00							
150									
QC	Memo	0.00							
Quality Control									

JUL 27 2015

15/7/28

AS-7-24

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

Picklist Print

July 22, 2015 10:28:04 AM

Page 1

Work Order ID: 134848

134848

Parent Item: D4842-041

D4842-041

Parent Item Name: Lower Cutter Assembly

Start Date: 7/22/2015

Required Date: 7/31/2015

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 13.04.30 NEW ISSUE DD VERF:JLM IPP
REV:B 13.11.01 AS PER DWG REV.B DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4839-1 *D4839-1* Blade		Manufactured	No				Each	10.0000		2		15/07/28	DAS 36 9-89
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				MF				10					
				133453				2		2			
				134649				8					
D4842-1 *D4842-1* Lower Cutter Deflector		Manufactured	No				Each	6.0000		1		15/07/28	DAS 36 9-89
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				MF				6					
				100670				1					
				107947				3					
				109250				2		1			
D4842-3 *D4842-3* Lower Cutter Body, LH		Manufactured	No				Each	3.0000		1		15/07/28	DAS 36 9-89
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				MF				3					
				107957				3		1			

Picklist Print

July 22, 2015 10:28:04 AM

Page 2

Work Order ID: 134848

134848

Parent Item: D4842-041

D4842-041

Parent Item Name: Lower Cutter Assembly

Start Date: 7/22/2015

Required Date: 7/31/2015

Start Qty: 1.00

Required Qty: 1.00

D4842-4

Manufactured No

Each 8.0000

D4842-4

Lower Cutter Body, RH

**

1

15/07/28 DAS 36 9-89

Location

Loc Qty

Loc Code

MF

8

108070

1

109252

7

MS21042L08

Purchased No

Each 860.0000

MS21042L 08

Nut

**

15/07/27

15/07/27 DAS 36 9-89

Location

Loc Qty

Loc Code

CA

101

m129682

101

ST260a

435

m131697

435

ST304

324

123900

16

m128401

102

m128429

3

m131317

203

MS27039-08-19

Purchased No

Each 470.0000

MS27039-08-19

Screw

**

15/07/27

15/07/27 DAS 36 9-89

Location

Loc Qty

Loc Code

ST273A

438

m131317

438

ST281

32

m127904

3

m131264

29

Picklist Print

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Work Order ID: 134848

134848

Parent Item: D4842-041

D4842-041

Parent Item Name: Lower Cutter Assembly

Start Date: 7/22/2015

Required Date: 7/31/2015

Start Qty: 1.00

Required Qty: 1.00

NAS1149FN832P

Purchased

No

Each

3,097.000

NAS1149FN832P

Washer

DAS

36

9-89

Location

Loc Qty

Loc Code

ST260a

1704

125268

1704

st268

1393

125268

472

M130388

921

12/18

15/17/27

18

MS21042L08
LOCKNUT

D4842-3 LOWER
CUTTER BODY LH

D4842-1 LOWER CUTTER DEFLECTOR

NAS1149FN832P WASHER

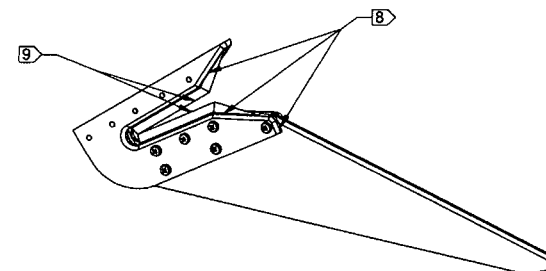
D4839-1 BLADE

D4842-4 LOWER
CUTTER BODY RH

MS27039-0819 SCREW

NAS1149FN832P WASHER

ITEM	QTY -041	P/N	DESCRIPTION
	X	D4842-041	LOWER CUTTER ASSY
1	2	D4839-1	BLADE
2	1	D4842-1	LOWER CUTTER DEFLECTOR
3	1	D4842-3	LOWER CUTTER BODY LH
4	1	D4842-4	LOWER CUTTER BODY RH
5	6	MS21042L08	LOCKNUT
6	6	MS27039-0819	SCREW
7	12	NAS1149FN832P	WASHER
8	A/R	LOCTITE 598	RTV SEALANT



D4842-041 LOWER CUTTER ASSEMBLY

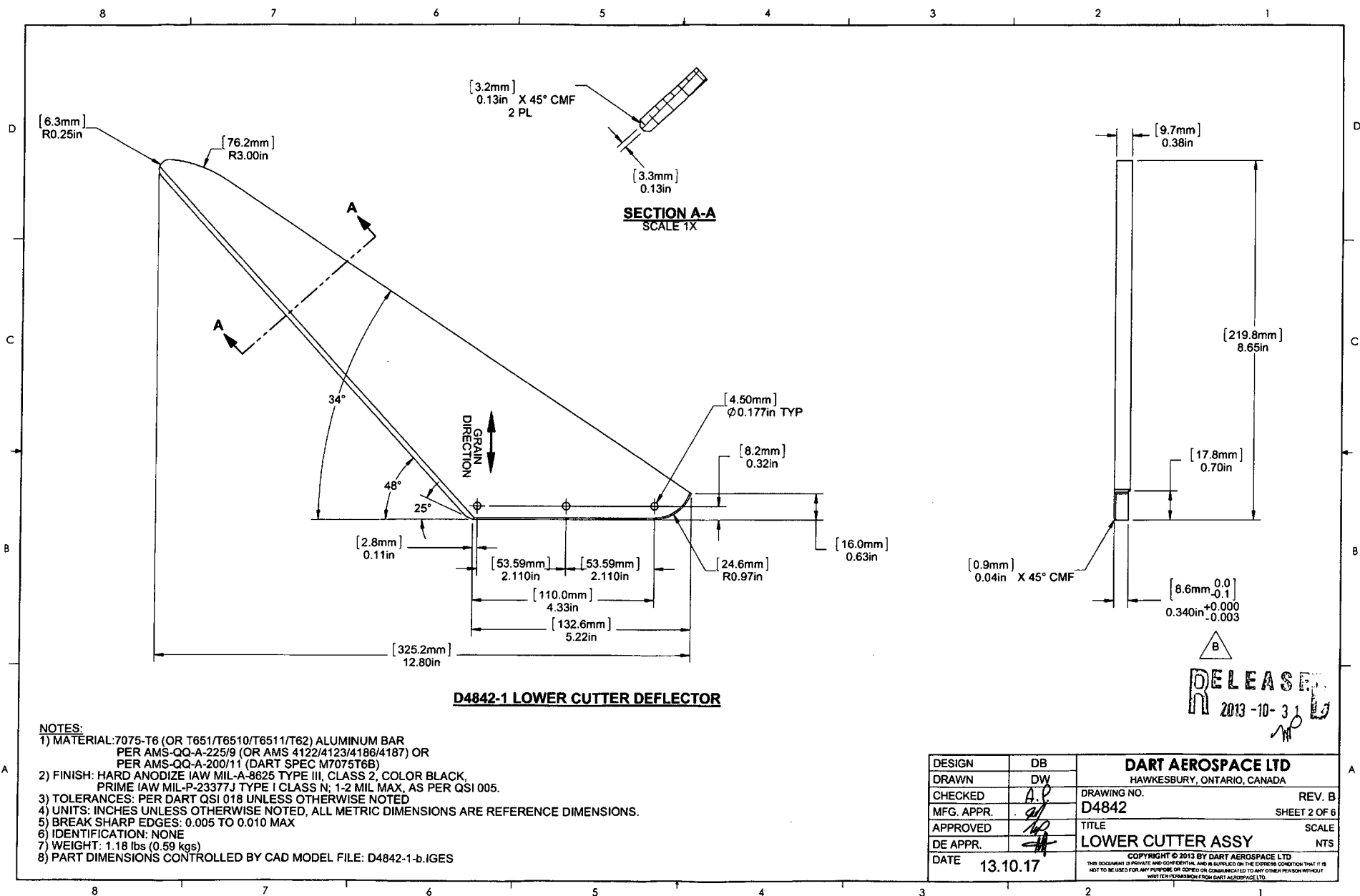
134848
5H
15/7/22

RELEASED
2013-10-31

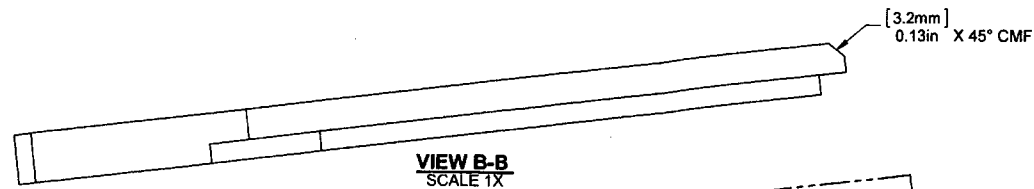
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: N/A
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4842-041", AGUSTA WESTLAND KIT NUMBER "TBD", REVISION, BATCH NUMBER AND MANUFACTURE DATE, USING AN X-TENSION STAMP, AS PER QSI 044 METHOD 6.2
- 7) WEIGHT: 2.79 lbs (1.26 KGS)
- 8) APPLY RTV SEALANT TO ALL FAYING SURFACES UPON ASSEMBLY
- 9) CUTTING EDGE INTENDED TO BE SHARP. DO NOT BREAK SHARP EDGE.

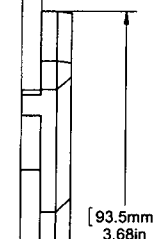
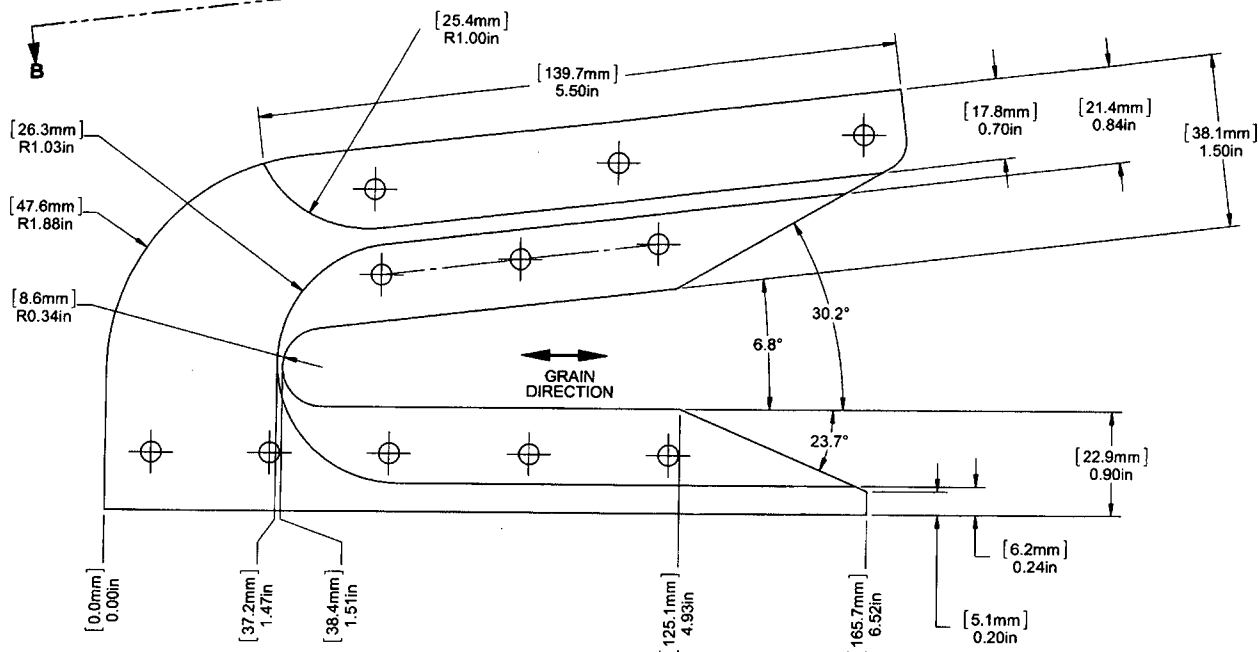
B	CORRECT TOLERANCES (ZN B1-2) (ZN B1-3, D2-3)	DW	13.10.17
A	NEW RELEASE	DB	13.05.23
REV.	DESCRIPTION	BY	DATE
DESIGN	DB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DW		
CHECKED	AP	DRAWING NO.	REV. B
MFG. APPR.	AP	D4842	SHEET 1 OF 6
APPROVED	AP	TITLE	SCALE
DE APPR.	AP	LOWER CUTTER ASSY	NTS
DATE	13.10.17	COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



8 7 6 5 4 3 2 1



[4.3mm^{+0.1}_{0.0}]
[0.168in^{+0.003}_{-0.000}] TYP



D4842-3 LOWER CUTTER BODY LH

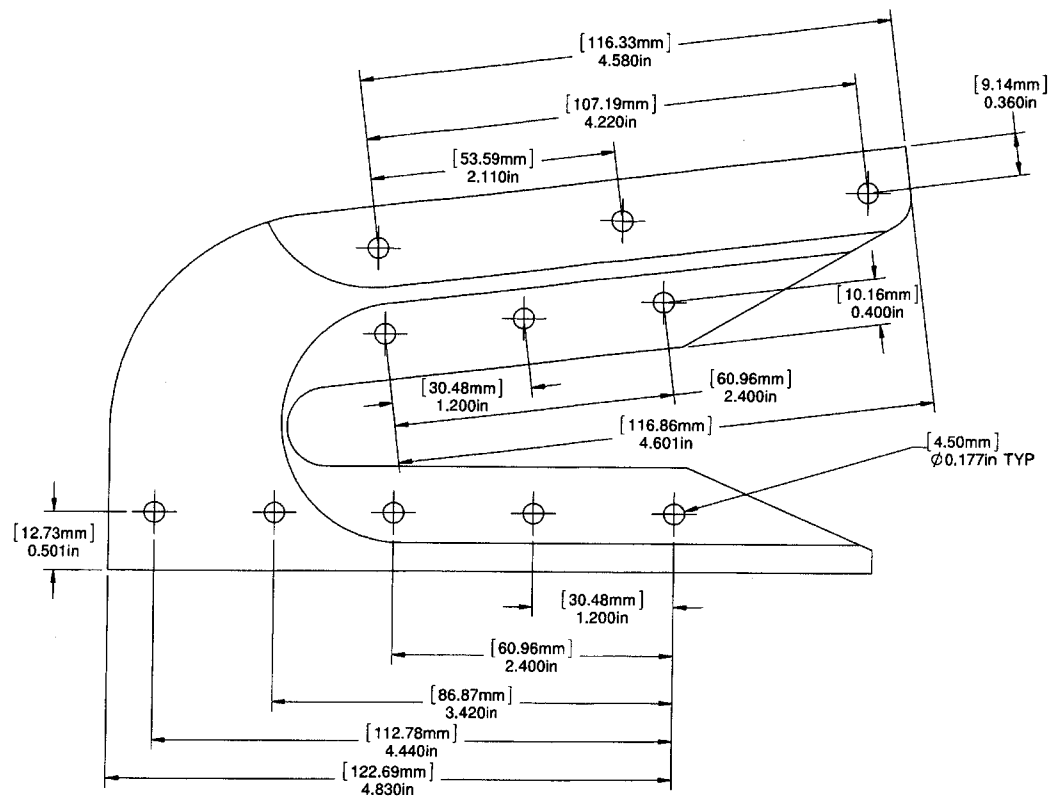
NOTES:

- 1) MATERIAL: 7075-T6 (OR T651/T6510/T6511/T62) ALUMINUM BAR
PER AMS-QQ-A-225/9 (OR AMS 4122/4123/4186/4187) OR
PER AMS-QQ-A-200/11 (REF DART SPEC M7075T6B)
- 2) FINISH: HARD ANODIZE IAW MIL-A-8625 TYPE III, CLASS 2, COLOR BLACK, AS PER QSI 017;
PRIME IAW MIL-P-23377J TYPE I CLASS N; 1-2 MIL MAX, AS PER QSI 005.
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED, ALL METRIC DIMENSIONS ARE REFERENCE DIMENSIONS.
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.49 lbs (0.22 kgs)
- 8) PART DIMENSIONS CONTROLLED BY CAD MODEL FILE: D4842-3-b.IGES

RELEASED
2013-10-31

DESIGN	DB	DART AEROSPACE LTD	
DRAWN	DW	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AP	DRAWING NO.	REV. B
MFG. APPR.	AP	D4842	SHEET 3 OF 6
APPROVED	AP	TITLE	SCALE
DE APPR.	AP	LOWER CUTTER ASSY	NTS
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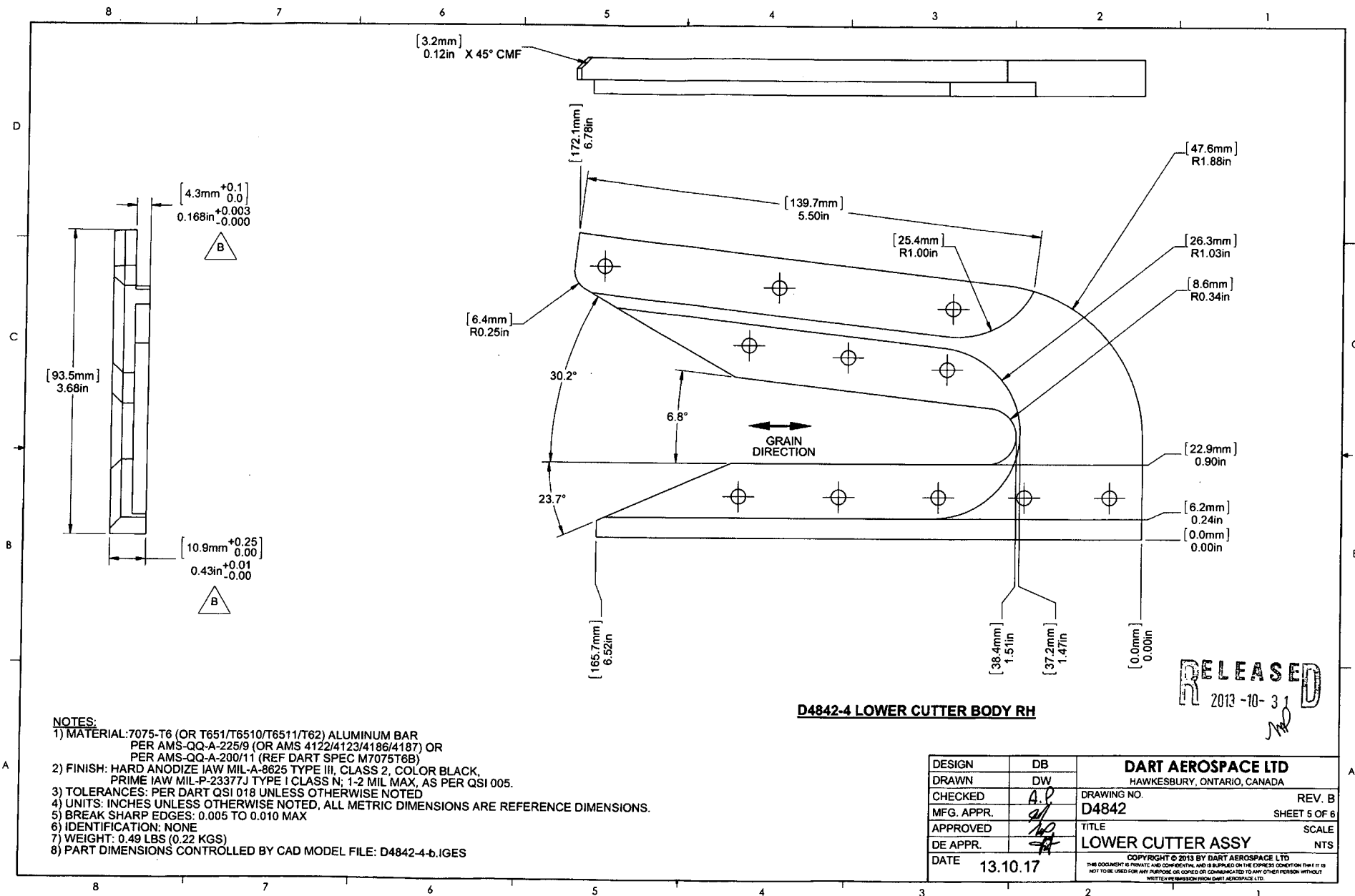
8 7 6 5 4 3 2 1



D4842-3 LOWER CUTTER BODY LH
(AUXILIARY VIEW)

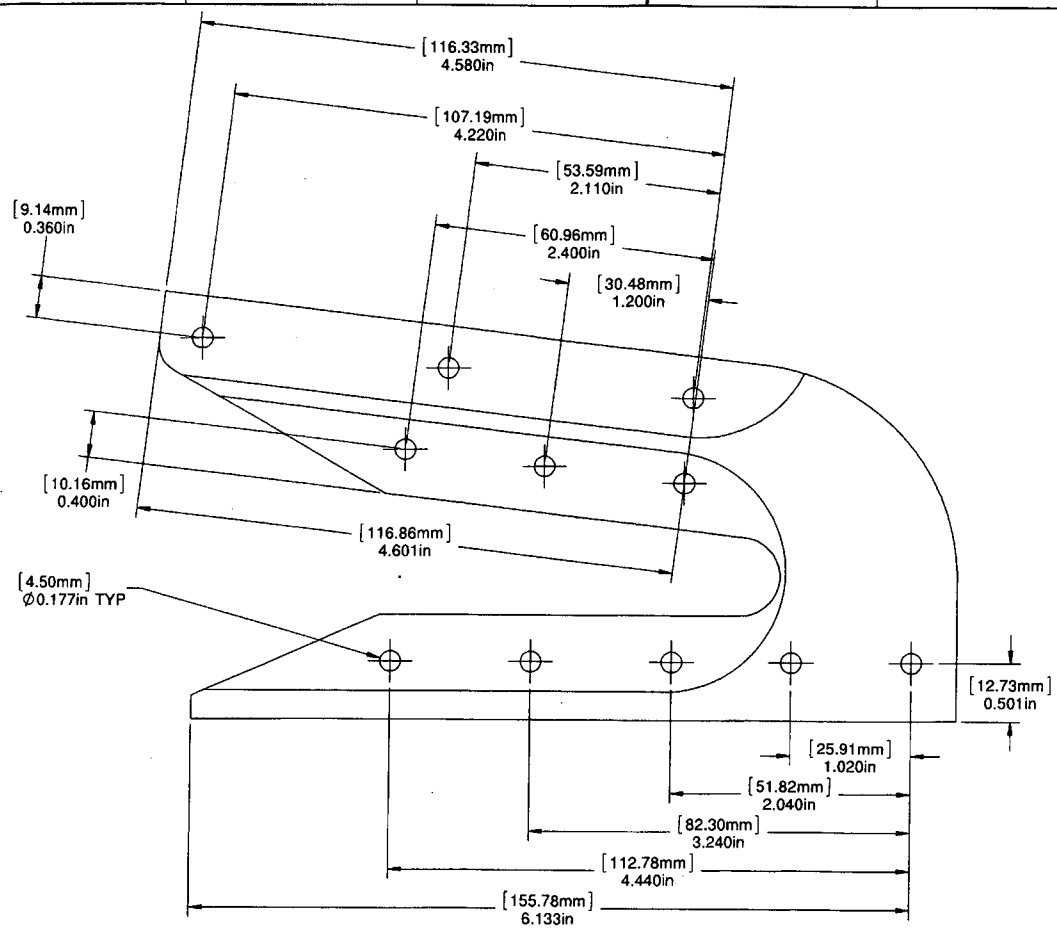
RELEASE
2013-10-31
MP

DESIGN	DB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DW		
CHECKED	AP	DRAWING NO. D4842	REV. B
MFG. APPR.	AP	SHEET 4 OF 6	
APPROVED	AP	TITLE	SCALE
DE APPR.	AP	LOWER CUTTER ASSY	NTS
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RELEASED
2013-10-31

D4842-4 LOWER CUTTER BODY RH



D4842-4 LOWER CUTTER BODY RH
(AUXILIARY VIEW)

RELEASE
2013-10-31

DESIGN	DB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DW		
CHECKED	A.P.	DRAWING NO.	REV. B
MFG. APPR.	21	D4842	SHEET 6 OF 6
APPROVED	24	TITLE	SCALE
DE APPR.	24	LOWER CUTTER ASSY	NTS
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